

Work Order ID 55223

January 12, 2010 1:27:38 PM



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Item ID: D4044-043

Accept



Setup Start



Revision ID:

Item Name: Center Rib Assembly

Stop



Start Date: 1/12/10 Start Qty: 2.00



Cust Item ID:

Required Date: 1/25/10 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 10-1-12

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D4044	PAT PA3	10/01/27							

100



Large Fab

Memo

0.00

MATERIAL CERTIFICATION
REQ'D UPON DELIVERY

10/01/27

Large Fab

- 1- Cut tube 60" and remove identification markings
- 2- Bend tube with manuel pipe bender as per dwg D4044-3
- 3- Drill and chamfer holes as per dwg D4044-3
- 4- Trim access tube material to finish size as per dwg D4044
- 5- weld bushing as per dwg D4044
- A/R S.S. rod Batch: M109212
- 6- grind welds flush

PD 10.01.26 ②

110



QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

10/01/26

Quality Control

PRELIMINARY ISSUE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 55223



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Start Date: 1/12/10 Start Qty: 2.00



Cust Item ID:

Required Date: 1/25/10 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC10- Inspect visual per QSI004- ground welds

0.00

0.00

10/01/26

QC

Quality Control

130

Identify as per dwg & Stock Location Basket

0.00

PD 10.01.26

Packaging

Packaging

140



QC21- Final Inspection - Work Order Release

0.00

10.01.26

QC

Quality Control

Memo

0.00

10-1-27

POSITIVE RECALL
EFFECTIVE 10/01/27 AUTH LL
RELEASED _____ DATE _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 1

January 12, 2010 1:27:44 PM

Work Order ID: 55223



Parent Item: D4044-043



Parent Item Name: Center Rib Assembly

Start Date: 1/12/10

Required Date: 1/25/10

Comments: IPP RevA: new issue DD 10/01/05 verified by:EC

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3759-1 		Manufactured	No			100	Each	31.0000	6.0000 			

Bushing

WarehouseLocation

Main Warehouse

WA

Loc Qty

Loc Code

53442

31

54072

2

100

29

PD 10.01.26

M304TS0.750W.049

Purchased

No

f

48.4054 10.5263

304 SQ Tube .75x.75x.049W

WarehouseLocation

Main Warehouse

M113763

PD 10.01.240

MAT

Loc Qty

Loc Code

103240

48.4054

106604

1.5816

107460

4.9307

109087

29.2779

109087

12.6152

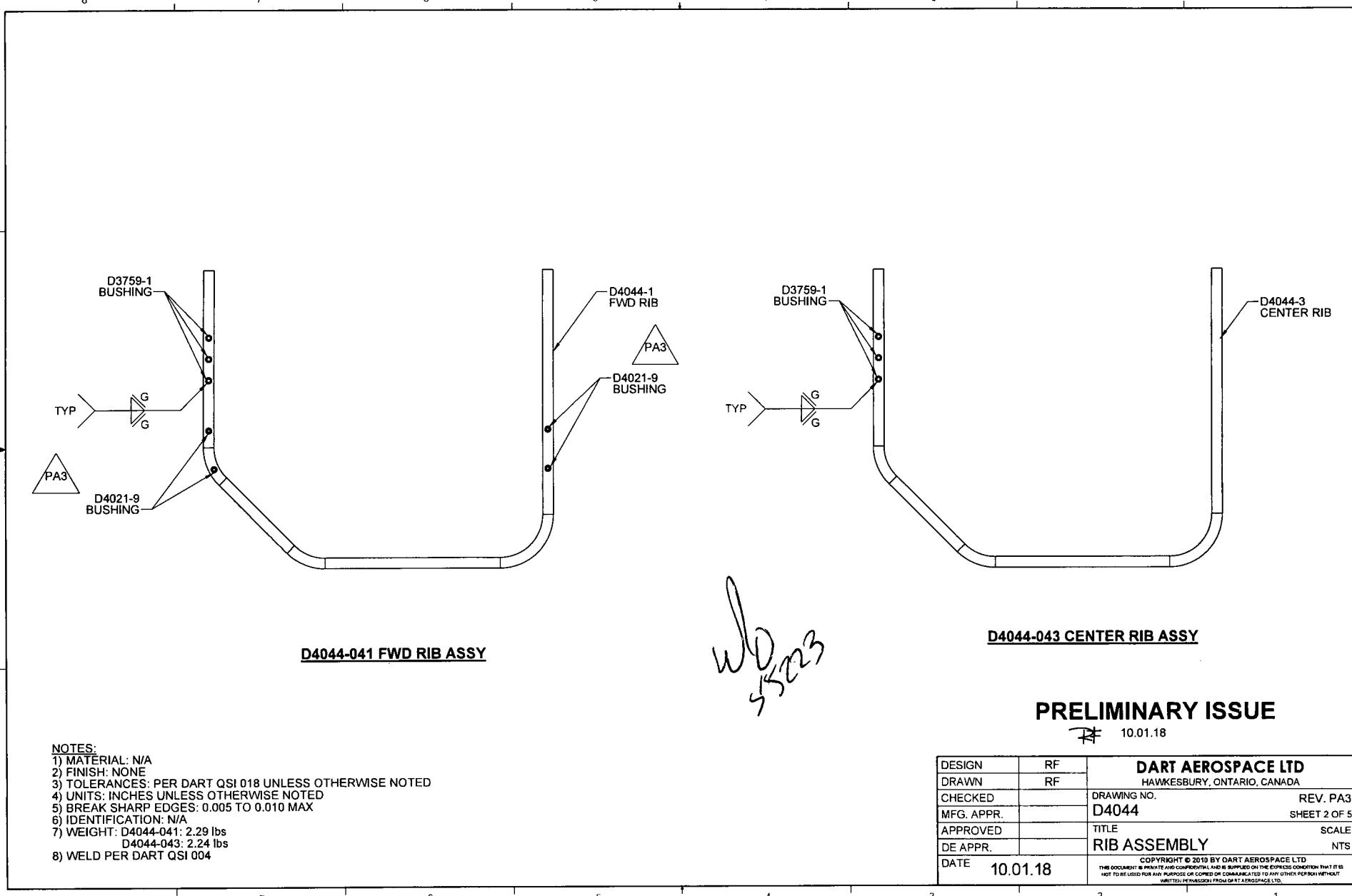
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

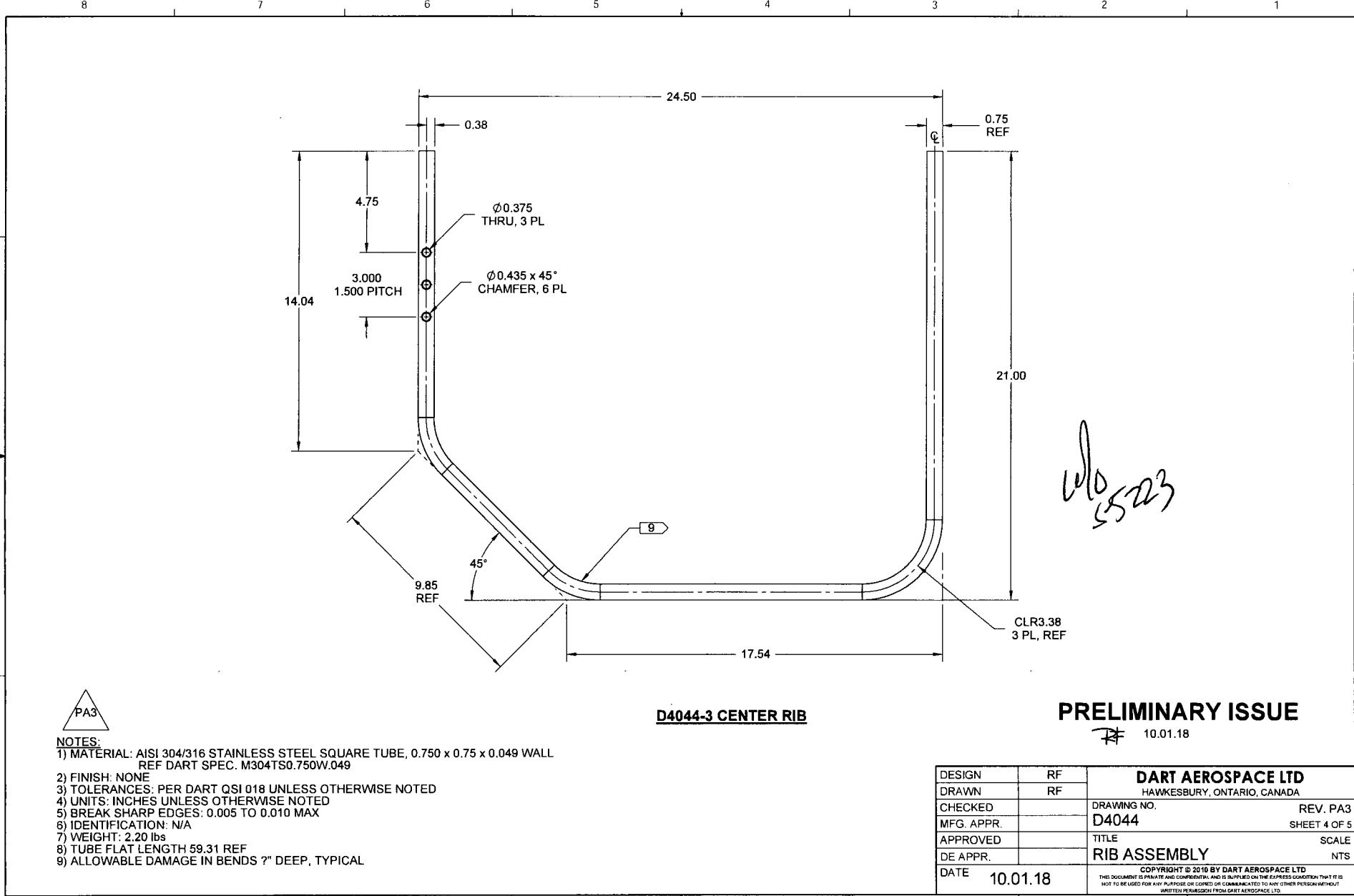
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries





Jan 26 10 01:56p

p.3

PHOENIX TUBE COMPANY, INC.

Manufacturer of Stainless Ornamental and Structural Tubing

CERTIFICATION OF TEST

Sold To: MAGNA STAINLESS INC.
5775 RUE KIERANSAINT-LAURENT QC H4S
CANCUSTOMER ORDER#: PO00691
DATE SHIPPED: 02/23/10
SIZE: 3/4SQ X 18 GA AW
SOURCE: USA D
VENDOR: NASShip To: MAGNA STAINLESS INC.
5775 RUE KIERANSAINT-LAURENT QC H4S
CANPhone#: 3391211 Ext:
ORDER#: 209402
QTY SHIPPED: 300.0
GRADE: 304 WELD: HF
HEAT#: 3DK8
TEST REPORT#: TR007424

Report Date: 11/28/07

Specification:

ASTM A554-08a

NO WELD REPAIR

WELDED / MILL-FINISH

OK P 10.01.26

P
C
S
O
D
IMERCURY IS NOT USED BY US AS AN ALLOYING MATERIAL NOR IS METALLIC MERCURY HANDLED IN THE VICINITY
OF OUR PROCESSING LINES. WE ARE NOT PRESENTLY AWARE OF ANY MERCURY CONTAMINATION.

Chemical Analysis

C	MN	P	S	SI	CR	NI	MO	CU	CO	N2
.058	1.564	.028	.015	.267	18.363	8.14	.256	.298	0	.042

Physical Analysis

Hardness	YIELD		TENSILE		OTHER	
	PSI	MPA	PSI	MPA	Percent EL	Percent RA
RB 66	49780	0	99490	0	54.1	0

THE CHEMICAL ANALYSES ARE CORRECT AS CONTAINED IN OUR CORPORATE RECORDS.

PHYSICAL PROPERTIES ARE DETERMINED WHILE MATERIAL IS IN STRIP FORM.

Melted & Manufactured in the USA FAR BAA complies, DFARS BAA complies, FAR TAA complies

CERTIFIED BY: Jane Kieran1185 WIN DR, BETHLEHEM, PA., 18017 - (610) 865-5337
FAX NUMBER: 610-865-4073*Sq. mill finish*